

ALPINE AERO TECH

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

## AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 69810-01  
Approval #: SH00-48 Serial #: 69801-08  
WO #: 2007-04 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

Aug 7/07  
DateJeff Clark  
Inspector's SignatureAERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

## AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Forward Beam Part #: 69830-01  
Approval #: SH00-48 Serial #: --  
WO #: 2007-05 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

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## AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Aft Beam Part #: 69831-01  
Approval #: SH00-48 Serial #: --  
WO #: 2007-05 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

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Aug 7/07  
DateJeff Clark  
Inspector's Signature

DUPLICATE

HELI DYNAMICS

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AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 69810-01  
Approval #: SH00-48 Serial #: 69801-06  
WO #: 2007-04 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: Modified with open front end and lid step IAW DCL704

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

July 6/07  
Date

Jeff Clarke  
Inspector's Signature

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AUTHORIZED RELEASE CERTIFICATE

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TCCA 24-0078  
AMF # 73-04

Product: Quick Release Forward Beam Part #: 69830-01  
Approval #: SH00-48 Serial #: --  
WO #: 2007-05 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

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TCCA 24-0078  
AMF # 73-04

Product: Quick Release Aft Beam Part #: 69831-01  
Approval #: SH00-48 Serial #: --  
WO #: 2007-05 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

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TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 69810-01  
Approval #: SH00-48 Serial #: 69801-07  
WO #: 2007-04 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: Modified with open front end and lid step IAW DCL704

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

May 25/07  
Date

Jeff Clark  
Inspector's Signature

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

# AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Forward Beam Part #: 69830-01  
Approval #: SH00-48 Serial #: --  
WO #: 2007-05 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

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May 25/07  
Date

Jeff Clark  
Inspector's Signature

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# AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
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Product: Quick Release Aft Beam Part #: 69831-01  
Approval #: SH00-48 Serial #: --  
WO #: 2007-05 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

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May 25/07  
Date

Jeff Clark  
Inspector's Signature

DUPLICATE

WORK ORDER 2007-05

Date opened: 30 January 2007

Project: Quick Release Cargo Basket Beams  
Type: Bell 206L Series, 407Batch Quantity: 3 Forward Beam Ass'y (69830-01)  
3 Aft Beam Ass'y (69831-01)Approval: SH00-48  
Drawing List: DCL698-1

<u>Fabrication and Assembly Drawing(s)</u>	<u>Description</u>
69830, Rev. 2	Forward Beam Ass'y
69831, Rev. 2	Aft Beam Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: \_\_\_\_\_

Inspector Signature: Aug 7/07 Jeff Clark. Date: \_\_\_\_\_

Drawing: 69830 Revision 2  
 Assembly: 69830-01 Forward Beam Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	69830-01	Forward Beam Assembly			
1	69830-03	Tube	CSA G40.21 50W, 1x2x0.125 tube	6055	
1	69830-04	Tube	CSA G40.21 50W, 1x2x0.125 tube	6055	
2	69830-05	Bushing	1018 Mild Steel, 5/8" Rod	951108	
1	69830-06	Strap	4130 Steel, 0.125" Sheet	6031	
1	69830-07	Block	1018 Mild Steel, 1/4" Sqr. Rod	4044	
1	69830-09	Cap	1018 Mild Steel, 0.025" Sheet	9506142	
1	69830-10	Cap	1018 Mild Steel, 0.025" Sheet	9506142	
1	69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	6049	
1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	6061	
1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	3005	
1	69830-23	Spring	15mm x 70 mm Spring	6063	
1	#10-32	Screw	Stainless Steel, Commercial	6069	
1	MS21044C3	Nut		1013	

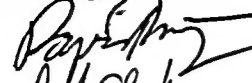
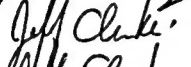

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2, AMS 5680A		<i>David R.</i>
Powder Coat	Drawing 69830			<i>Jeff Clarke.</i>
Final Inspection	Drawing 69830			<i>Jeff Clarke.</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 69831 Revision 2  
 Assembly: 69831-01 Aft Beam Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	69831-01	Aft Beam Assembly			
1	69831-03	Tube	CSA G40.21 50W, 1x2x0.125 tube	6055	
1	69831-04	Tube	CSA G40.21 50W, 1x2x0.125 tube	6055	
1	69831-05	Tube	CSA G40.21 50W, 1x2x0.125 tube	6055	
2	69830-05	Bushing	1018 Mild Steel, 5/8" Rod	951108	
1	69830-06	Strap	4130 Steel, 0.125" Sheet	6031	
1	69830-07	Block	1018 Mild Steel, 1/4" Sqr. Rod	4044	
1	69830-09	Cap	1018 Mild Steel, 0.025" Sheet	9506142	
1	69830-10	Cap	1018 Mild Steel, 0.025" Sheet	9506142	
1	69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	6049	
1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	6061	
1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	3005	
1	69830-23	Spring	15mm x 70 mm Spring	6063	
1	#10-32	Screw	Stainless Steel, Commercial	6069	
1	MS21044C3	Nut		1013	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2, AMS 5680A		
Powder Coat	Drawing 69831			
Final Inspection	Drawing 69831			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	BEAM MODIFIED TO ACCOMMODATE SLIDING DOOR	BJC	06/09/2006
2	BEAM MODIFIED FOR 2 KEYWAY ATTACHMENT	BJC	09/11/2006

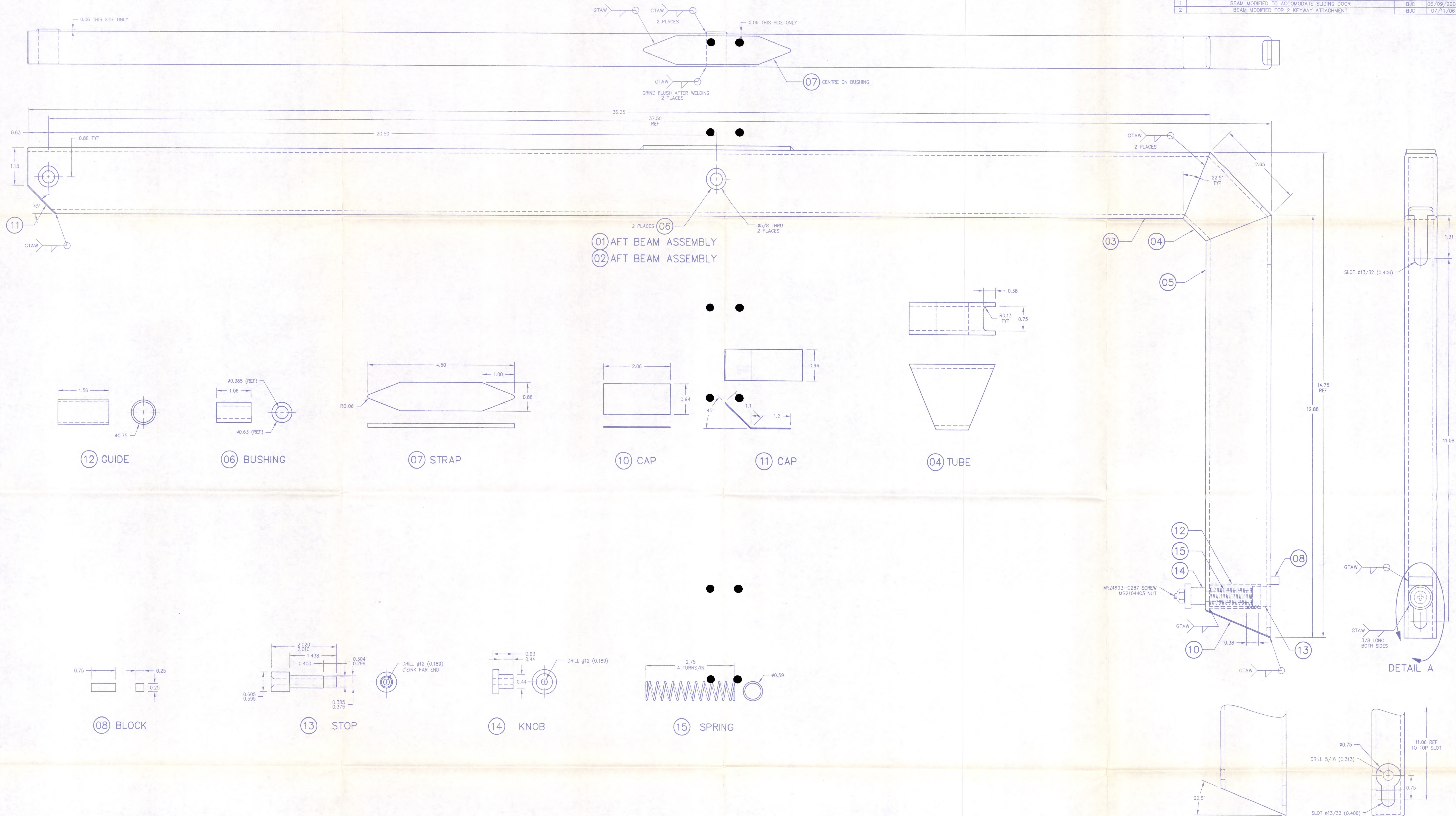
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AWS256SC.  
WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT FOR 4130/HSS STEEL.  
WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT FOR STAINLESS STEEL.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO INSTALLATION
4. FORWARD BEAM ASSEMBLY (69830-02) MAY BE USED AS A DIRECT REPLACEMENT FOR FORWARD BEAM ASSEMBLY (69830-01).

Q2	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1	MS21044C3	BUT				
1	1	#10-32	C/SUNK SCREW		STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
1	1	69830-23	14	SPRING		COMMERCIAL	0.75 ROD
1	1	69830-22	13	KNOB	6061-T6 ALUMINUM	QQ-A-200/8	0.625 ROD
1	1	69830-21	12	STOP	6061-T6 ALUMINUM	QQ-A-200/8	0.625 ROD
1	1	69830-11	11	GUIDE	304 STAINLESS STEEL	ASTM A429	0.75 X 0.065 RND. TUBE
1	1	69830-20	10	CAP	321 STAINLESS COND.	AMS 5510	0.025 SHEET
1	1	69830-10	09	CAP	4130 STEEL COND. N	MIL-S-18729	0.025 SHEET
1	1	69830-19	09	CAP	321 STAINLESS COND.	AMS 5510	0.025 SHEET
1	1	69830-09	08	CAP	4130 STEEL COND. N	MIL-S-18729	0.025 SHEET
1	1	69830-07	07	BLOCK	304 STAINLESS STEEL	ASTM A479	0.25 SOR ROD
1	1	69830-16	06	STRAP	304 STAINLESS STEEL	MIL-S-5059	0.100 SHEET
1	1	69830-06	06	STRAP	4130 STEEL COND. N	MIL-S-18729	0.125 SHEET
1	1	69830-05	05	BUSHING	304 STAINLESS STEEL	ASTM A429	0.625 X 0.120 TUBE
1	1	69830-05	05	BUSHING	MILD STEEL	AISI 1010/1020	0.625 ROD
1	1	69830-14	04	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	69830-04	04	TUBE	HSS STEEL	CSA G40.21 50W	1 X 2 X 0.125 TUBE
1	1	69830-13	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	69830-03	03	TUBE	HSS STEEL	CSA G40.21 50W	1 X 2 X 0.125 TUBE
1	1	69830-02	02	FORWARD BEAM ASSEMBLY (STAINLESS STEEL)			
1	1	69830-01	01	FORWARD BEAM ASSEMBLY			

APPROVALS		DATE		<h1 style="text-align: center;">AERO DESIGN LTD.</h1> <p>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M          2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7          tel: (403) 250-8027      <a href="mailto:aerodesign@telusplanet.net">aerodesign@telusplanet.net</a></p>	
DRAWN: JEFF CLARKE		06 APR 2006			
CHECKED: E. BURGIN					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		BELT 126L / 407 QUICK RELEASE CARGO BASKET FORWARD SIDE FABRICATION			
DECIMALS	ANGLES		DRAWN: DWM		REV:
.XXX ±0.010	±1/2"		SCALE 1 : 1		<div style="display: flex; justify-content: space-around; font-size: 2em; font-weight: bold;"> <span>A0</span> <span>69830</span> <span>2</span> </div>
.XX ±0.03			SHEET 1 OF 1		
.X ±0.1					





## NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C.  
WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT FOR 4130/HSS STEEL.  
WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT FOR STAINLESS STEEL.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY.
4. AFT BEAM ASSEMBLY (69831-02) MAY BE USED AS A DIRECT REPLACEMENT FOR AFT BEAM ASSEMBLY (69831-01).

1	1	MS21044C3	NUT																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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APPROVALS		DATE		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027    cell: (403) 250-8333    aerodesign@telusplanet.net			
DRAWN:	JEFF CLARKE	06 APR 2006					
CHECKED:	E. BURGIN						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				BELL C602 / 407 QUICK RELEASE CARGO BASKET AFT BEAM FABRICATION			
DECIMALS		ANGLES		DWG. SIZE		DWG. NO.	
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